

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023753**Date Inspected:** 09-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13AW, 14E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Flour (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13AE. He has also verified the Non-Destructive Testing requirments for each weldment that includes the NDT process (UT, MT, RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

TRIAL ASSEMBLY YARD

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 09080 from ZPMC for Trial Assembly Yard. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as 14E. The weld designations reviewed are as follows.

SEG3019AB-103~114, 021~024, 029, 030, 041~046, 117, 118, 128~135

SEG3019H-053, 056, 059, 061

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SEG3019H-264~267
SEG3019Y-060~063
SEG3019L-327~330
SEG3019-271, 345~348

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding(SMAW), and Flux Cored Arc Welding(FCAW) process.

ZPMC QC is identified as Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: I Rib Stiffener

PCMK: SEG3007P

Weld Number: 108, 113

Welder: 040706

WPS-B-P-2211

Component: I Rib Stiffener

PCMK: SEG3019K

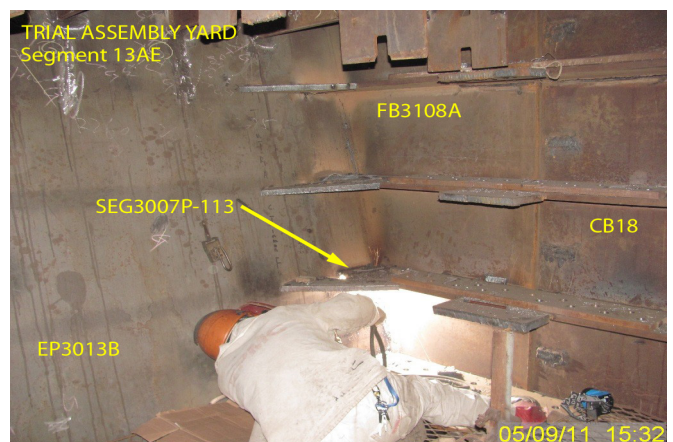
Weld Number: 005

Welder: 044779

WPS-345-SMAW-2G-FCM-Repair-1

WR 20937

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
